

Date: Thursday, 9/14/2006 7:28:13 AM
 User: Kim Johnston

Process Sheet

Split 85 04/10/2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT PLATE ASSEMBLY
Job Number	: 28553		
Estimate Number	: 12304		
P.O. Number	: <i>N/A</i>	Part Number	: D3467045
This Issue	: 9/14/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3467 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 26948	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/6/2006 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: A New Issue 06-04-24 EC Est Rev: B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3467049	BAFFLE & DEFLECTOR ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D3467-49	Baffle ass'y	<i>B28581</i>

2.0	D34673	TUBE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
2	D3467-3	Tube	<i>B28585</i>

3.0	D34675	AFT PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D3467-5	aft plate	<i>B26108</i>

4.0	D346711	BRACKET
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
2	D3467-11	Bracket	<i>B26781</i>

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Job Number: 28553

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D346717

TOP COVER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3467-17 Shourd Plate

B26111

6.0

D346719

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3467-19 Doubler

B28583

7.0

D346720

doubler RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3467-20 Doubler

B28584

8.0

NAS1031C3W

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nutplate

M101041

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-045

mf. 06/10/05. ①

mf. 06/10/05. ①

10.0

QC5/11

INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

SB 06/10/10

①



ser:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Job Number: 28553

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

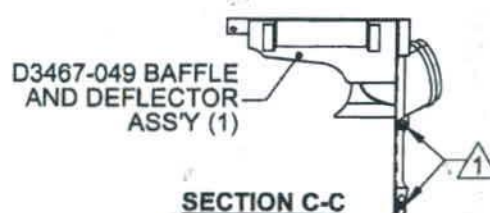
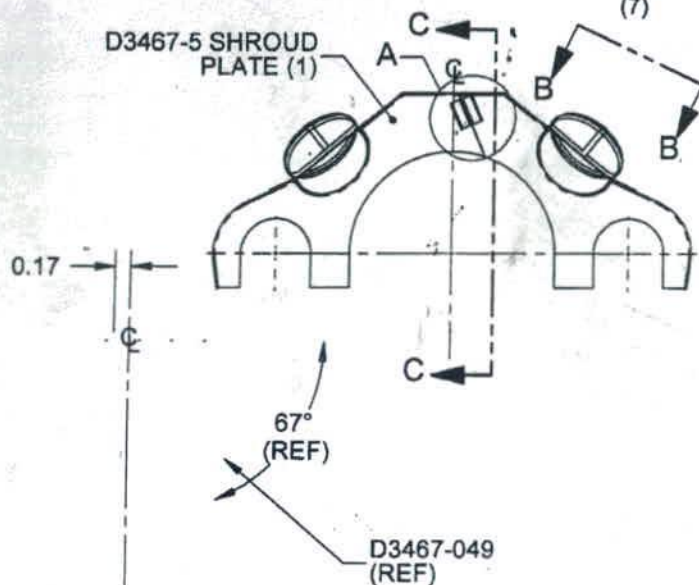
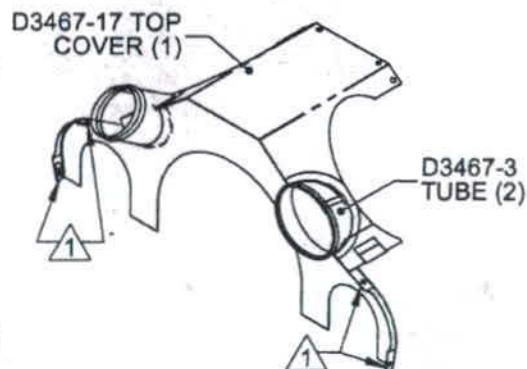
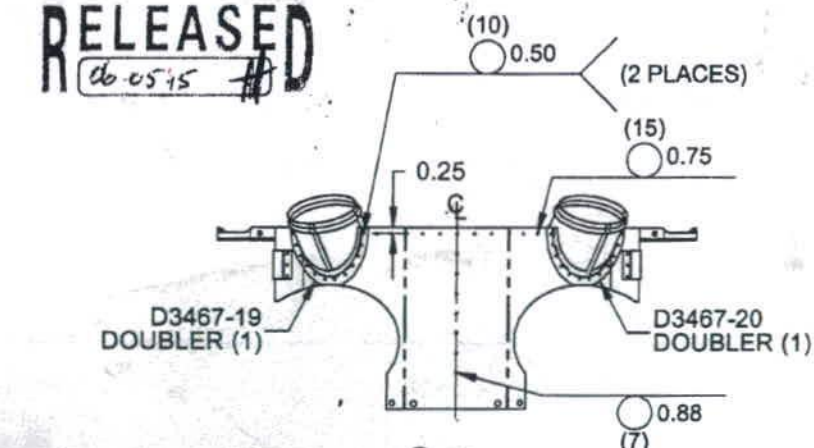
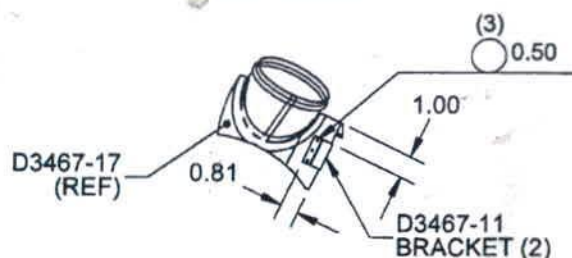
Job Completion



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DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 3 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:8

RELEASED
06-05-15**SECTION C-C****VIEW B-B: WELDING D3467-11**
D3467-047 NOT SHOWN FOR CLARITY
(2 PLACES)**DETAIL A**
SCALE 1:2**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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NO. 30

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Melanie Fautoux
Joint Welding Procedure Spot Welding
Part number and Job number D 3467-045

TEST WELDS REQUIRED

BASE METAL 304 L G WELDING PROCESS Spot
Penetration Complete ☒ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☐ N/A

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

N/A

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/03 Qualifier Sylvie Poulsen

